

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004044**Date Inspected:** 27-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

CWI Inspector: Mr. Sun Bo

Heavy Bay #3:

ZPMC QC Inspector Mr. Sun Bo informed the QA Inspector that he and ABF Inspector Mr. Kevin Chen are performing initial visual inspections of the welds of deck panels DP596-001 and DP571-001 in heavy bay #3 and they are ready for QA visual inspections. The QA Inspector marked a few additional areas of weld overlap and identified to Mr. Chen that one of the areas that is marked as needing to be blended appears to have a depth in excess of 1mm deep. Mr. Chen then marked this area as needing to be weld repaired instead of being blended. QA Inspector documented the initial visual inspections on the yellow inspection status tags that are attached to the deck panel.

Bay 7

ZPMC notification of witness inspection document #00927 dated 8-27-2008 states that ZPMC QC inspection personnel will be conducting final ultrasonic inspections of 80 OBG corner diaphragm plate welds in bay #7 at

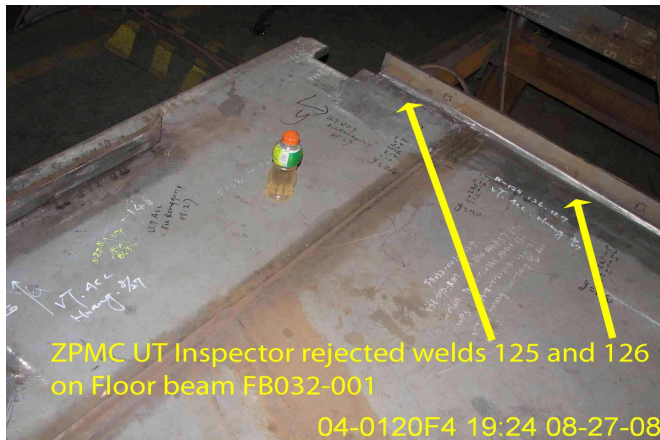
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1430 hours. At 1500 hours the QA Inspector observed three ZPMC ultrasonic Inspectors in the location where these corner diaphragm plate welds were located. At 1900 hours the QA Inspector observed ZPMC ultrasonic Inspectors have conducted ultrasonic inspections of approximately 20 of these welds and each of the 20 welds is marked "UT Reject". The remaining 60 welds do not appear to have been ultrasonically inspected by ZPMC personnel.

The QA Inspector observed floor beam welds FB030-001-127, FB032-001-125, FB032-001-126 and FB032-001-127 had previously been ultrasonically inspected by ZPMC Inspection personnel earlier today and each of these four welds is marked as "UT Reject".

QA performed AWS D1.5 ultrasonic inspection of floor beam welds FB030-001-125, FB030-001-126, FB030-001-146 and FB032-001-146 and items observed appear to comply with project specifications. Each of these welds had been identified as UT Accept by ZPMC inspection personnel earlier today. See the photographs below and the TL6027 ultrasonic test report for additional information.



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
